

CENTARI[®] 501

SUPER PRODUCTIVE 2K ENAMEL

Description

2-component topcoat system for solid colours for use on cars, buses and trucks.
Composition based on acrylic copolymer.

Products

AM	Centari [®] MasterTint [®]
AF101	Super Productive 2K Binder
AK260	High Solids Activator
256S	Activator Fast
AB380	Basecoat Thinner
AB385	Hi-Temp Thinner
XB383	Standard Thinner
XB387	High Temperature Thinner

Properties

- Centari[®] 501 gives excellent appearance, a high gloss finish, very good hiding and low consumption.
- Gives a fast set up time, superior polishability and resistance to waterspotting.
- Can be used for spot, panel and overall repair.

Substrates


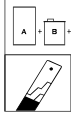








- all OEM finishes and DuPont primers



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PRODUCT PREPARATION

	Colour tools	See colour formula.				
	Mixing ratio	Centari® 501 AK260 256S AB380/XB383 AB385/XB387	Standard	Fast	High temp.	
			4	4	4	
			1	/	1	
			/	1	/	
			1	1	/	
		/	/	1		
	VOC	545-590 g/li				
	Pot life at 20°C	4 h				
	Spray viscosity at 20°C	DIN 4	17-19 s			
		FORD 4	17-19 s			
		AFNOR 4	19-21 s			
	Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip	Spray distance		
			1.2-1.4 mm	20-25 cm		
			1.4-1.8 mm	20-25 cm		
			1.3-1.5 mm	10-15 cm		
			1.0-1.2 mm	20-25 cm		
	Spray pressure	Gravity feed	3-4 bar			
		Suction feed	3-4 bar			
		HVLP	0.7 bar at nozzle			
		Pressure feed	4-6 bar			
	Number of coats	2				
	Flash time	10 min. between coats. 10 min. before bake.				
	DFT	50-60 µ				
	Drying	With AK260	15°C	20°C	30°C	30 min. x 60°C
		Dust-free	12 min.	10 min.	9 min.	imm.
		Dry to handle	3 h 30 min.	2 h 30 min.	1 h 30 min.	imm.
		Tape-free	6 h	5 h	4 h	imm.
		With 256S	15°C	20°C	30°C	20 min. x 60°C
		Dust-free	10 min.	9 min.	8 min.	imm.
		Dry to handle	2 h	1 h 15 min.	1 h	imm.
	Tape-free	5 h	4 h	4 h	imm.	
	IR drying*	Flash time	5 min.	* guideline for short/medium wave IR equipment		
		Distance	80 cm			
		Half power	5 min.			
		Full power	15-20 min.			
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.						

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RECOMMENDED USE

Surface preparation

1. Clean surface with water and soap.
2. Degrease with 3919S. Wipe dry with clean cloth.
3. Repair according to damage.
4. Sand:
dry mechanical P320 - P400 (finally with P500 will give best results);
wet P800 - P1000.
5. Degrease with 3920S.
6. Wipe dry and tack rag.

Topcoat application

On well prepared surface, apply 2 full coats with 10 min. flash between coats.

Chemical resistance

When fully cured, Centari[®] 501 is resistant to short exposures of the chemicals as listed:

sodium hydroxide	10 %	battery acid
sulphuric acid	20 %	toluene
hydrochloric acid	20 %	xylene
phosphoric acid	20 %	glycol
ammonia	10 %	brake fluid, petrol

Equipment cleaning

Use 3608S.

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RECOMMENDED USE (con'd)

Recoatability

At any time after tape-free time.

Product data

Theoretical coverage: 6-8 m²/li at recommended DFT - ready-to-spray

Products	Packages (li)	Storability at 20°C (year)
AM1x Centari [®] MasterTint [®]	1	2
AM94 Centari [®] MasterTint [®]	1	2
AM95 Centari [®] MasterTint [®]	1	2
AM7xx Centari [®] MasterTint [®]	1	3
AMxx Centari [®] MasterTint [®]	1 - 4	4
AF101	4	2
AK260	1 - 5	2
256S	1 - 5	2
AB380	1 - 5 - 20	2
AB385	5	2
XB383	1 - 5 - 20	2
XB387	5	2

Remarks

- Centari[®] MasterTints[®] have to be thoroughly mixed before weigh-out and the Centari[®] 501 colour has to be mixed immediately after weigh-out.
- Close can of AK260 and 256S tightly immediately after use, as these products will react with humid air and water and lose their hardening effect.
- For structured and/or flat colours, see specific TDS.
- Material has to be at room temperature (18-20°C) before use.

Safety

Consult Material Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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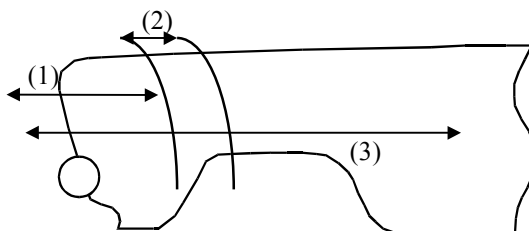
REPAIR SYSTEMS

Spot repair

1. Clean surface with water and soap.
2. Degrease with 3919S and wipe dry with clean cloth.
3. Repair with recommended undercoats.
4. Sand primed spots as recommended.
5. Prepare complete blending area with an ultra fine sanding pad or with 600S.
6. Degrease with 3920S.
7. Wipe dry and tack rag.
8. The following spot repair methods can be used:
 - AK450 Centari® Blending Clear method;
 - AK350 Centari® Blending Thinner method.

AK450 Centari® Blending Clear method

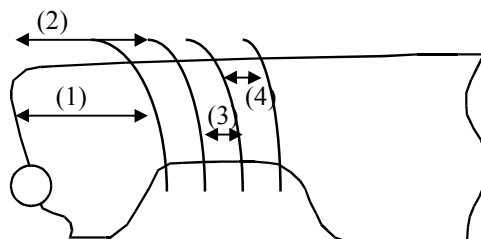
- ① Apply 1st coat Centari® 501.
Flash time: 10 min.
- ② Extend 2nd coat Centari® 501 beyond the previous one.
Flash time: 5 min.
- ③ Apply 1 coat of the activated blending clear over the entire panel.



Activate 7 parts AK450 with 1 part AK260 or 4 parts of AK450 with 1 part of 256S. Use mixing rod.

AK350 Centari® Blending Thinner method

- ① Apply 2 coats Centari® 501, extending 2nd coat beyond the 1st.
Flash time: 5 min.
- ② Dilute 1 part of the remaining Centari® 501 with 1 part AK350. Apply 1 coat extending beyond the previous ones.
- ③ Dilute 1 part of the remaining paint with 1 part AK350. Apply another coat extending again further into the panel.
- ④ Mistcoat repair zone immediately with pure AK350.



If necessary, balance out the gloss level by polishing with 1500S or 3000S after complete hardening of the repair.